

Work Order ID 84870

May-29-12 1:00:10 PM

84870

Page 1

Item ID: D3564-9

Revision ID:

Item Name: Wearshoe

Start Date: 29/05/2012 Start Qty: 25.00

Required Date: 16/07/2012 Req'd Qty: 25.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 12/05/30 Tooling:

QC:

Date:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog
Rev: 1 2-Deburr if necessary

301.003

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

73

12-6-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 Form Joggle as per Dwg D3564 on brake using Jig DT 8157

25

SP 12/06/18

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

12/06/18

(12/06/18)

150

150

Large Fab

Large Fab

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
1122030 Weld hardcoat as per Dwg D3564

(X12)

MAL

12/06/18

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Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

Subcell 19

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

Subcell 19

(+12)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:30 OVEN TEMPERATURE:

FINISH TIME:

3200F

9:00

12X ✓

m.f.
12/06/19

m12/279

W/O:		WORK ORDER CHANGES					
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Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

12x f all 11/06/19

200

Identify as per dwg & Stock Location

0.00

200

Packaging

Memo

0.00

Packaging

12x M-L 12/06/19

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/06/19 12-06-19

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Picklist Print

May-29-12 1:00:13 PM

Page

Work Order ID: 84870

84870

Parent Item: D3564-9

D3564-9

Parent Item Name: Wearshoe

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	271.9720	1.41	37.10526			
**													

M304S16GA

304/316 Sheet 063

IB12-6-3

Location

MAT020

121626

121889

Loc Qty

271.972

143.972

128

Loc Code

121626

25

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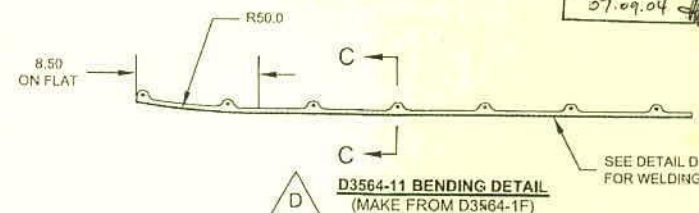
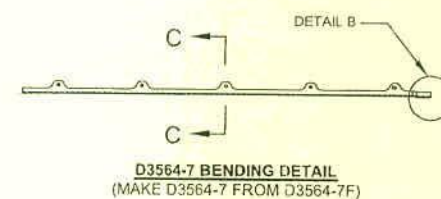
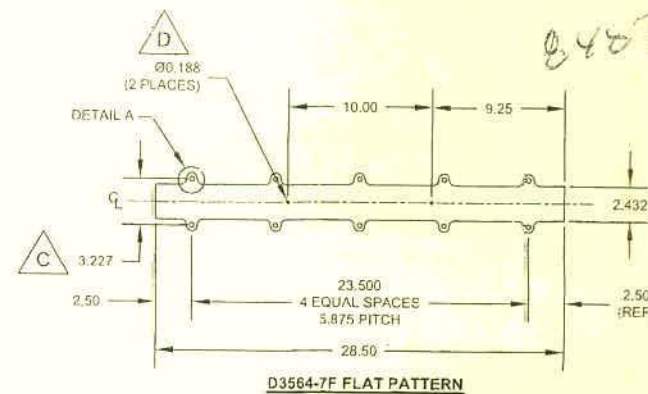
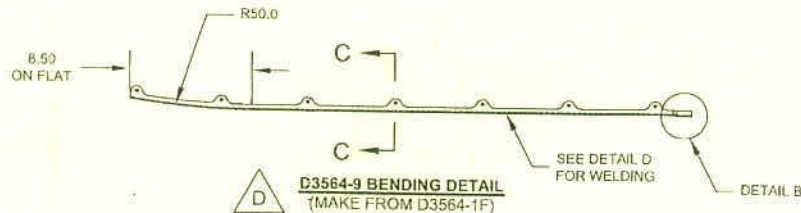
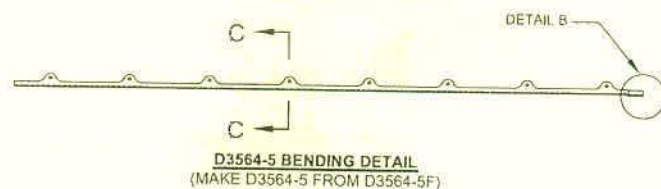
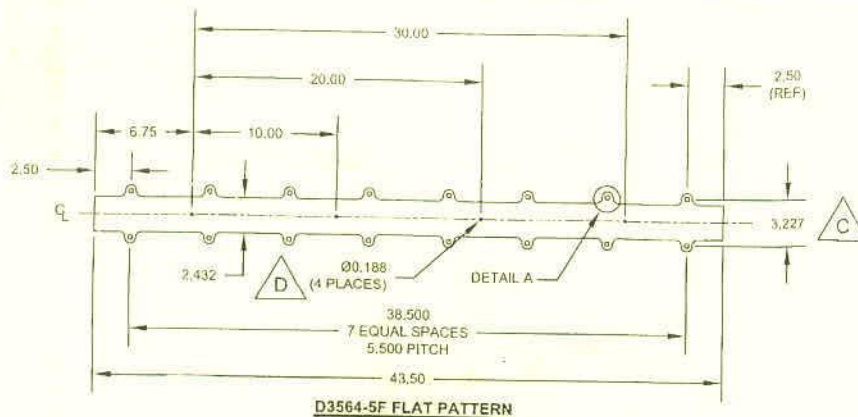
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NOTE: Date & initial all entries



UNDER REVIEW
OK 07.11.25

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	C.B.		
CHECKED	PH	DRAWING NO.	REV: D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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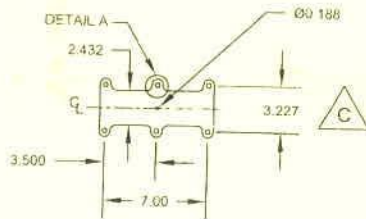
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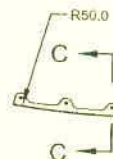
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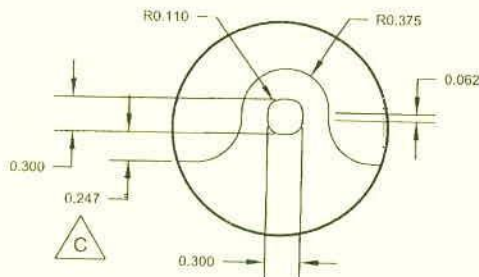
NOTE: Date & initial all entries



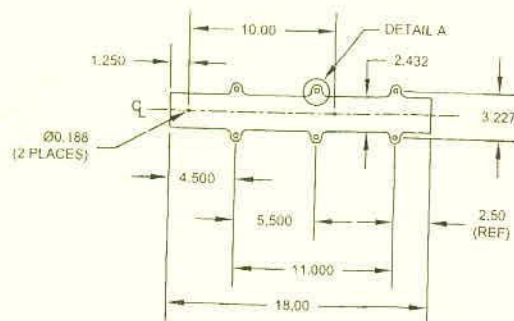
D3564-13F FLAT PATTERN



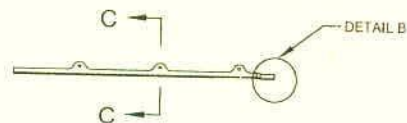
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



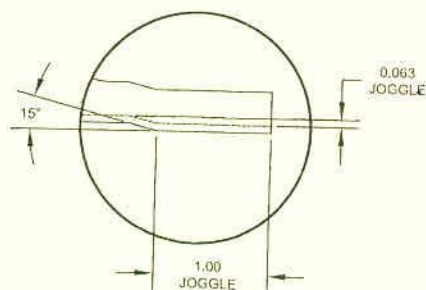
DETAIL A
SCALE 1:1



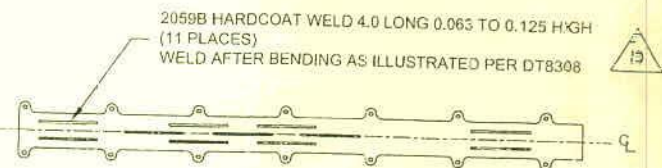
D3564-15F FLAT PATTERN



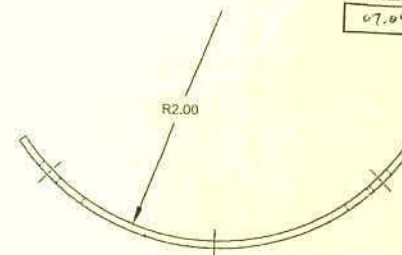
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL B
SCALE 1:1



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1

RELEASED
07.09.04

UNDER REVIEW
07.11.20

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV: D
MFG. APPR.	8/1/02	D3564	SHEET 3 OF 3
APPROVED	1/1/02	TITLE	SCALE
DE APPR.	1/1/02	WEARSHOE	1:8
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